



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

6F9540V00231
Job Sheet 178070



Part No: 6F9540V00231

Job Qty: 1 ea

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 8/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 10 2018
100	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging1-6		AUG 10 2018
105	QC	1 pcs	8/6/18	8/6/18	0.00	0.00	QC4		AUG 10 2018
120	Packaging	1 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-1		AUG 10 2018
125	DC	1 pcs	8/6/18	8/6/18	0.00	0.00	DC		AUG 10 2018
130	QC21-FG	1 Ea	8/6/18	8/6/18	0.00	0.00	QC21		AUG 21 2018

Part Op 120 - Identify and pack for shipping as per PPP 6F9540V00231

Descriptions: 125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 Ea (1 ea)	90-Start up Operation	5100979

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D169-841-015	1	0	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 9:51 AM Dart.lajeunesse.marie



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order	Rework	Skid-tube	Cross tube	Water Jet	Engineering
Part	Scrap	Machining	Small Fab	Prod. Eng. Coord.	Quality
NC	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other
Date :	Inapproved	Large Fab	Composite	Supplier	
QTY Effective :		MRB (QS1042) Approval			
Disposition		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

Root Cause		FAULT CATEGORY	
Environment	No Re-verification	Temperature/Cure	Positioned Wrong
Design	Operator	Set-up	Outside Dimensions
Doc/Data	Offset/Setup	BOM/Route	Over/Under tolerance
Equip/Tooling	Supplier	Broken/Damage/Defect	Part Incorrect
Handling/Pre	Training	Inspection Incomplete/Unqualified	Part Lost/Missing
Material	Use for Testing	Contamination	Part Moved
Internal Transport	Poor Information	Countersink	Drawing
Tribal Knowledge	Rushing	Cut Too Short	Finish
LOA	Product Improvement	Instructions Incomplete/Unclear	Misread
Substation	Process Improvement	Drill Holes	Turning Sequence
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		

OTHER :	

Container No: S101005

Part: 6F9540V00231

Job No: 178070

Serial No/Batch: S101005

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 08/10/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

		Supplier Concession				PAGE 1 of 2	PLANT Leonardo Helic. - Vergiate	
Supplier NC N.	AWC-009/00		Date	21.08.2018		AW Concession	400000075161	
P/N	6F9540V00231		Grade/Category	NC		Purchase Order	4801761207	
Part Description	PROTECTR, CCP ASSY LOWER		Batch Quantity	2,000		Drawing Issue		
AW NC	FRANCESCO NAVA		Defective Quantity	2,000		A/C Type/Model	AW6	
Supplier	DART AEROSPACE LTD		Contract					
Defect PR10 - Working different from requirements (spe - * 21.08.2018 08:41:44 FRANCESCO NAVA (46232) * See supplier document attached Cause of Defect								
Repetitiveness (same P/N - Defect Code) NO ☐ YES ☒ (1)								
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist Inputs: Investigation Report n. Compliance Report n. * 21.08.2018 09:51:23 MARCELLO STEFANELLI (9273) * As for the attached consideration, the deviation doesn't affect the strenght and functionality of the part, it is acceptable use as is.								
Classification of Deviation from Type Design I.a.w. EASA Part 21A.91 : Minore/B								
Defect effect						Limitations		
	Before Repair		After Repair					
Safety	☐	YES	☐	YES	☐	YES (to specificity) ☒ NO		
Life or Duration	☐	YES	☐	YES	☐			
Strenght	☐	YES	☐	YES	☐			
Performances	☐	YES	☐	YES	☐			
Interchangeability	☐	YES	☐	YES	☐			
Reliability	☐	YES	☐	YES	☐			
Maintainability	☐	YES	☐	YES	☐			
Installability	☐	YES	☐	YES	☐			
Testability	☐	YES	☐	YES	☐			
Only Appearance	☐	YES	☐	YES	☐			
No Effect	☒	YES	☐	YES	☐			
Repair Proposal:					Decision			
					☐ Use rep. with spec.repair(not yet applied) ☐ Use repaired with known repair(yet applied) ☒ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification					Re-submit after Repair			
☐ MAJOR ☒ MINOR					☐ YES ☒ NO			
Mark part with Concession					Method :			
☒ NO ☐ YES								
ATE	MARCELLO STEFANELLI		CPE			Date	21.08.2018	
Checks and tests to be performed								
Repair registration								
with repair WO ☐ Number:								
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)	
S101005	☒	☐	☐		☐	☐	☐	
S101006	☒	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	2,000	Use Repaired (Q.ty)		Scrap (Q.ty)			
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI			FRANCESCO NAVA				
Date	21.08.2018			21.08.2018				



Supplier Concession

PAGE
2 of 2

PLANT
Leonardo Helic. - Vergiate

Supplier NC N.	AWC-009/00	Date	21.08.2018	AW	400000075161	Purchase Order	4801761207
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 AgustaWestland A Finmeccanica Company		CONCESSION				Pag. 1 of 2									
Manuf. Doc. N.	AWC-009	Date	2018/08/13	AW Doc. N.		Purchase Order	4801761207								
AW P/N	6F9540V00231	S/N / Batch Number	S101005 S101006	Grade	A	AW Drawing Issue	B								
Description	Protector, CCP Lower Assembly			Batch Q.ty	2	Defective Q.ty	2								
Manufacturer	Dart Aerospace LTD			Model	AW169										
Defect(s) Description															
The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.															
<table border="1" style="width: 100%;"> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/08/13 2018/08/13</td> </tr> </table>								Department	Inspector	Signature	Date	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/08/13 2018/08/13
Department	Inspector	Signature	Date												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/08/13 2018/08/13												
Defect(s) Cause															
Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.															
<table border="1" style="width: 100%;"> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/07/13 2018/07/13</td> </tr> </table>								Department	Inspector	Signature	Date	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13
Department	Inspector	Signature	Date												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13												
Corrective Action						Complete Before									
Dart Aerospace HBY requesting drawing update to allow for grain direction change on D4842-1															
<table border="1" style="width: 100%;"> <tr> <th>Department</th> <th>Inspector</th> <th>Signature</th> <th>Date</th> </tr> <tr> <td>Quality Assurance</td> <td>DAS 16 9-89 DAS-16-9-89</td> <td> E. Downing</td> <td>2018/07/13 2018/07/13</td> </tr> </table>								Department	Inspector	Signature	Date	Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13
Department	Inspector	Signature	Date												
Quality Assurance	DAS 16 9-89 DAS-16-9-89	 E. Downing	2018/07/13 2018/07/13												

For "MANUFACTURER" SUPPLIERS ONLY

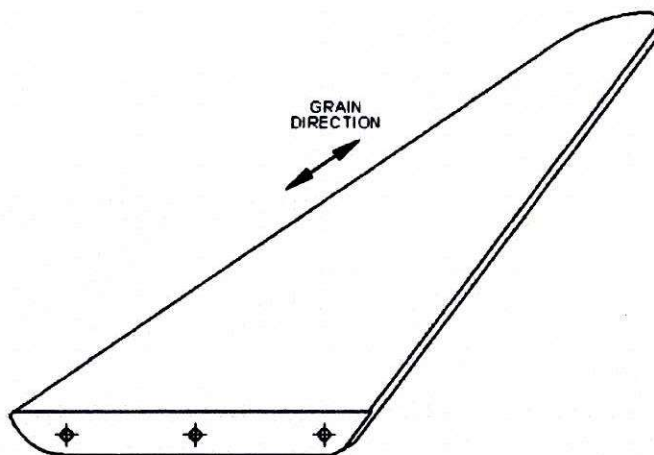
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report
Compliance report

n: NCR18-6764
n...N/A.....

Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



	Defect effects		Limitations
	Before any repair	After any repair	
	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Safety	☐ yes	☐ yes ☐ no	
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal		Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☐ Scrap	
Concession Classification	☒ Major ☐ Minor		Submit after repair ☐ yes ☐ no